

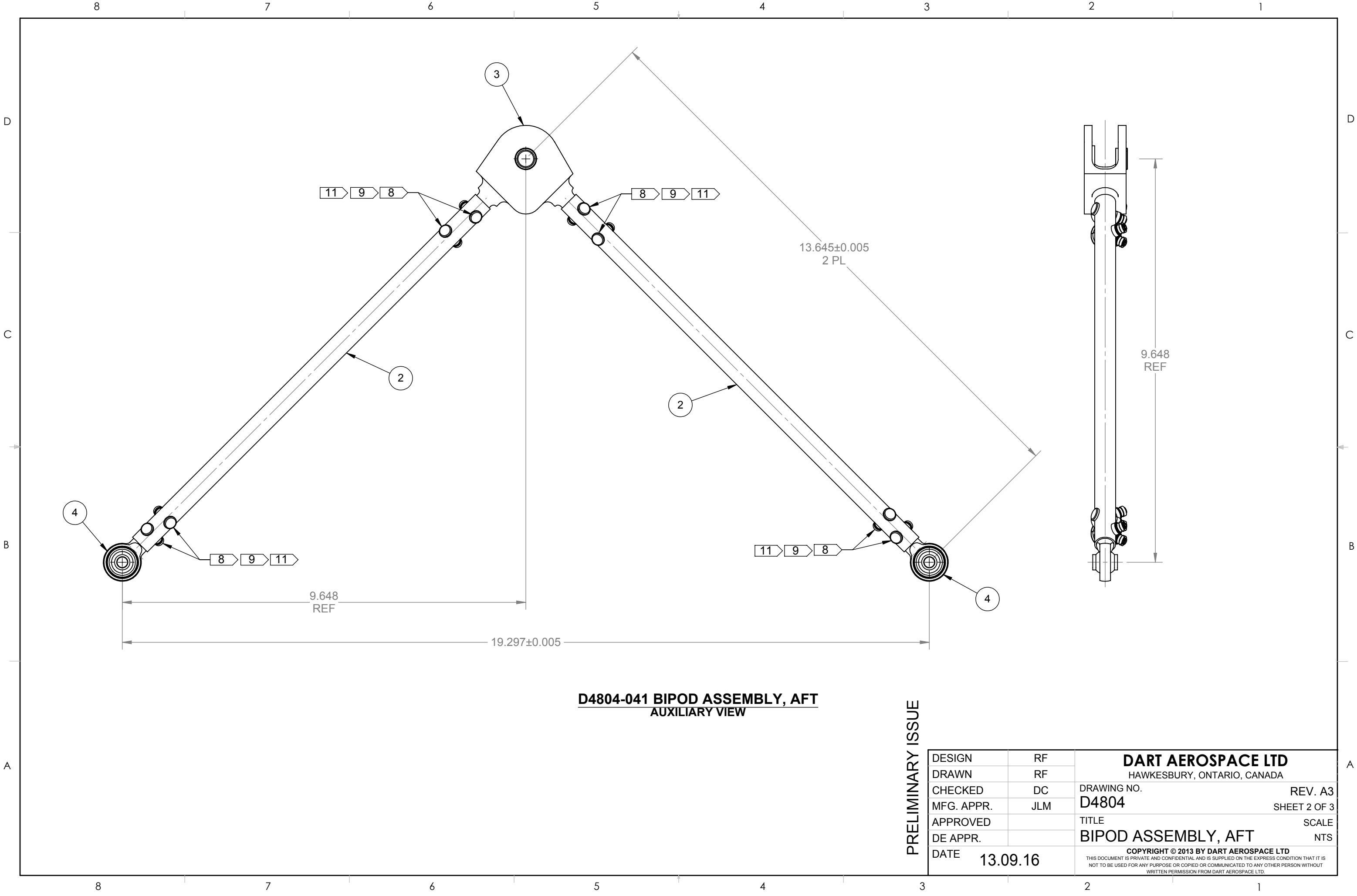
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4804-041	BIPOD ASSEMBLY, AFT
2	2	D4804-1	STRUT
3	1	D4807-041	SUPPORT ASSEMBLY
4	2	D4808-041	ROD END BEARING ASSEMBLY
5	8	HL20PB5-8	HI-LOK PIN
6	8	HL86-5	HI-LOK COLLAR

D4804-041 BIPOD ASSEMBLY, AFT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.68 lbs
 - 8) ALIGN PILOT HOLES IN D4807-041 WITH PILOT HOLES IN D4804-1.
ALIGN PILOT HOLES IN D4808-041 WITH PILOT HOLES IN D4804-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9954
 - 9) INSTALL PIN/COLLAR AND ROD END WITH HYSOL EA934NA WHILE STILL WET
 - 10) ASSEMBLE PER DART TOOL DT9954
 - 11) INSTALL HL20PB5-8 HI-LOK ORIENTATION AS SHOWN

PRELIMINARY ISSUE

A2	NEW ISSUE		RF	13.09.16
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	DC	DRAWING NO.		REV. A3
MFG. APPR.	JLM	D4804		SHEET 1 OF 3
APPROVED		TITLE		SCALE
DE APPR.		BIPOD ASSEMBLY, AFT		NTS
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CHECKED	DC	DRAWING NO.	REV. A3
MFG. APPR.	JLM	D4804	SHEET 2 OF 3
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